

February-23-15 10:37:45 AM

Page 1

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Work Order ID 130019

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130019

Page 2

Item ID: D4775-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut Assembly
 Start Date: 2/23/15 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00				(10)			DAS 38 9-88
130									
QC	Memo	0.00							MAR 11 2015
Quality Control									
140	Identify as per dwg & Stock Location: <u>st sk</u>	0.00				10			DAS 27 8-83
140									
Packaging	Memo	0.00							MAR 12 2015
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							MLJ 15-03-12
Quality Control									

15.3-12

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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130019

D4775-041

Required Qty: 10.00

AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1 *D4775-1* Strut Tube		Manufactured	No		128521	110	Each	0.0000	1	10	**	10 FF	MAR 05 2015
D4777-1 *D4777-1* Rod End Bearing		Manufactured	No			110	Each	16.0000	1	10	**	FF	MAR 05 2015
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST127	8129849 *			16		4			
				127488				6					
				128451				10		6			
D4776-1 *D4776-1* Basket Strut Clevis		Manufactured	No			110	Each	20.0000	1	10	**	FF	MAR 05 2015
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST126				20					
				127822				20		10			
D4776-5 *D4776-5* Spacer		Manufactured	No			110	Each	65.0000	4	40	**	FF	MAR 05 2015
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST127	130075			65		15			
				127743				24					
				128531				41		25			

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Picklist Print

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Page 2

Work Order ID: 130019

Parent Item: D4775-041

Parent Item Name: Strut Assembly

130019

D4775-041

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 10.00

Required Qty: 10.00

AN3-10A	Purchased	No	110	Each	208.0000	2	20	
AN3-10A								
Bolt								

FF

MAR 05 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	116	
m127817	16	
<u>m131320</u>	100	
ST338a	92	
11119	2	
m130466	90	

20

MS21042L3	Purchased	No	110	Each	2,793.000	2	20	
MS21042L3								
Nut								

FF

MAR 05 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	420	
M130922	420	
GA	996	
<u>M131317</u>	996	
ST305	1377	
112385	7	
113537	15	
116549	22	
M131264	594	
M131624	739	

20

MS21209-F615	Purchased	No	110	Each	69.0000	1	10	
MS21209-F615								
Heli-Coil								

FF

MAR 05 2015

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	69	
<u>m131270</u>	69	

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